

Work Order ID 74988

74988

Page 1

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH

Stop *NS2*

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 11/10/14 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

Switzky

JG MLJ 11-12-14

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

October-14-11 10:34:18 AM

74988

Page 2

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

*11/11/17**11/11/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

74988

Page 3

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: *M118735 8611-11-17*

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

8 u l u l i s

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

8 u l u l i s

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988***74988***

Page 4

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

IT 11-11-18 (8)

SAD 11/11/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

74988

Page 5

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>119319</u> exp. date: <u>12/08/13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M118735</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

DL 11/11/22

DL 11/11/22

BE11-11-29

DL 11/11/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988

October-14-11 10:34:18 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 14/10/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 28/10/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O	0.00
---	------

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

74988

Page 7

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1x 11/12/01

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:40
320 °F
3:10

1x 11/12/01

210

QC3- Inspert Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 BL 11-12-12

W118434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

October-14-11 10:34:18 AM

74988

Page 8

Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH
 Start Date: 14/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220	HandFinish	0.00				1	BL 11-12-12		
Hand Finishing	Memo 1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00							
230	HandFinish	0.00				1	BL 11-12-12		
Hand Finishing	Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: <u>N/A</u> 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>119443</u> EXP DATE: <u>12-1</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110348</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>114596</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988***74988***

Page 9

October-14-11 10:34:18 AM

Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74988

October-14-11 10:34:18 AM

74988

Page 10

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 14/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

Rev I

11/12/15

11/12/15

C Liu 2/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

October-14-11 10:34:27 AM

74988

D350-636-011

Required Date: 28/10/2011

Required Qty: 1.00

Comments:	IPP Rev:I	02.09.25	Rearranged procedure steps	KJ	
	IPP Rev:J	06-03-23	As per Rev D	JLM	
	IPP Rev:K	06-07.13	As per dsi9343	EC	
	IPP Rev:L	07-07-28	Added SS Wearplates(Rev E)	JLM	Verf:EC
	IPP Rev:M	08-04-22	update steps 4, 13	DD	verified by:EC
	IPP Rev:N	08-09-23	revF as per dwg	DD	verified by:ec
	IPP Rev:O	09-02-06	apply antiseize on AN8C21A bolts	as per PAR09-010	
	DD	verf:EC			IPP Rev:P 10.06.22 revise
	seq110	DD	verf:EC	IPP Rev:Q 10.10.01	as per IIN revH
DD	verf:EC				

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *D.3492-1* Plug		Manufactured	No			230	Each	158.0000	8	8			
									**			BL 11-12-12	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FP			158						
					69531		8						
					73402		70						
					74444		80						
D3492-3 *D.3492-3* Plug		Manufactured	No			230	Each	117.0000	8	8			
									**			BL 11-12-12	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				FP	76236		117						
					71838		37						
					74447		80						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:27 AM

Page 2

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

95.0000

8

8

NAS1611-010

O-RING

**

11-12-12

Location

Loc Qty

Loc Code

FP

119438

81

117460

8

118077

1

118612

72

FP-A

14

110915

14

NAS1149D0863J

Purchased No

250

Each

130.0000

2

2

NAS1149D0863.J

WASHER

**

Location

Loc Qty

Loc Code

ST298

130

118078

130

D2744

Manufactured No

110

Each

66.0000

1

1

D2744

Cap

**

DEC-11-17

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

53

71861

53

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:27 AM

Page 3

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

13.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location

Loc Qty

Loc Code

LG

75021

13

66875

8

73253

5

D2743

Manufactured No

160

Each

217.0000

8

8

D2743

Crossbolt Spacer

**

Location

Loc Qty

Loc Code

LG

159

71839

95

73403

64

LG001

58

67766

4

68251

54

D2739

Manufactured No

160

Each

2.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG

76867

2

72155

2

D3490-3

Manufactured No

160

Each

46.0000

4

4

D3490-3

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

46

73295

46

October-14-11 10:34:27 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160 Each 54.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 11-11-28
*B76233 *4*

Location Loc Qty Loc Code

LG 52

67773 5

69823 6

71841 41

LG001 2

62450 2

ALS4-1032-225 Purchased No

220 Each 2,610.000 38 38

ALS4-1032-225

Insert

**

AR 11-12-12

Location Loc Qty Loc Code

ST282 2610

108696 758

110768 62

118386 860

118966 ✓ 930

38

D3793-3 Manufactured No

230 Each 11.0000 1 1

D3793-3

Wearshoe

**

AR 11-12-12

Location Loc Qty Loc Code

FP001 11

74593 ✓ 11

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Page 5

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

113.0000

1

1

AN8C35A

BOLT

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP

77

117511

11

118286 ✓

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

19.0000

1

1

D3793-1

Wearshoe

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP001

6

73422

6

FP018

13

74591 ✓

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

18.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP

8

69903

8

FP007

1

61689

1

FP008

9

67788

1

71887 ✓

8

D3794-3

Manufactured No

230

Each

34.0000

1

1

D3794-3

Gasket

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP002

34

73423

6

74530 ✓

14

74596

14

AN6C44A

Purchased No

230

Each

113.0000

4

4

AN6C44A

BOLT

**

BR 11-12-12

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

111

118387

41

118985 ✓

40

119125

30

4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Page 7

Work Order ID: 74988

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

74988

D350-636-011

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

67.0000

1

1

MS21083C8

NUT

**

BL 11-12-12

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

60

115884

0

118354

10

118614 ✓

50

D3536-25

Manufactured

No

230

Each

19.0000

1

1

D3536-25

Gasket

**

BL 11-12-12

Location

Loc Qty

Loc Code

FP012

19

75039

7

74526

12

74595

D3631-1

Manufactured

No

230

Each

107.0000

8

8

D3631-1

Washer

**

BL 11-12-12

Location

Loc Qty

Loc Code

ST072

107

75548

107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Page 8

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each 14.0000 1 1

D3791-1

Wearplate

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP017

14

62239

2

74598

12

AN960C10L ~~AS~~ NAS1149C0332 Purchased No

230 Each 0.0000 38 38

***AN960C10I ***

washer

119780

**

38 BR 11-12-12

D2745 Manufactured No

230 Each 165.0000 8 8

D2745

Bushing

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP-A

3

69529

3

ST023

162

71835

162

AN3C5A Purchased No

230 Each 1,316.000 34 34

AN3C5A

Bolt

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1309

116419

28

117343

110

117764

169

117872

2

118451

500

119127

500

34

October-14-11 10:34:28 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

230 Each 33.0000 3 3

D3537-1

Wearpad

**

BR 11-12-12

Location

Loc Qty

Loc Code

FP001

7436
73395

26

26

3

FP017

69817
70686

7

5

2

230 Each 345.0000 1 1

**

BR 11-12-12

NAS1149C0832R

Purchased No

NAS1149C0832R

WASHER

Location

Loc Qty

Loc Code

FP-B

114915

17

17

1

ST297

114915

328

328

230 Each 232.0000 4 4

**

BR 11-12-12

AN3C6A

Purchased No

AN3C6A

BOLT

Location

Loc Qty

Loc Code

FP-A

111982

1

1

ST351

111982

231

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

176

1

3

119249

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

92.0000

8

8

NAS1611-013

O-RING

**

BR 11-12-12.

Location

Loc Qty

Loc Code

FP

119307.

55

8.

117291

2

117887

53

FP-A

37

116582

5

118384

32

D3535-25

Manufactured

No

230

Each

15.0000

1

1

D3535-25

Wearshoe

**

BR 11-12-12.

Location

Loc Qty

Loc Code

FP018

74505

15

1

62233

1

73424

2

74592

12

D3794-1

Manufactured

No

230

Each

24.0000

1

1

D3794-1

Gasket

**

BR 11-12-12.

Location

Loc Qty

Loc Code

FP014

24

74529

12

74594 ✓

12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Page 11

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

505.0000

4

4

MS21043-6

NUT

**

11-12-12

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

485

112314

275

117887

10

118384

200

4.

D3493-1

Manufactured

No

250

Each

55.0000

2

2

D3493-1

Washer

**

2

Location

Loc Qty

Loc Code

ST062

55

70697

17

71846

38

2

MS21083C8

Purchased

No

250

Each

67.0000

2

2

MS21083C8

NUT

**

M 119630 11/12/11

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

6

118077

6

ST303

60

115884

0

118354

10

118614

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		8						

NOTE: Date & initial all entries

Picklist Print

October-14-11 10:34:28 AM

Work Order ID: 74988

74988

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

69.0000

2

2

AN8C21A

BOLT

**

Location

Loc Qty

Loc Code

ST345

69

118045

19

118758

50

NAS1515H3L

Purchased

No

230

Each

117.0000

4

4

***NAS1515H3I ***

WASHER

**

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

77

113362

57

118686

20

D2741

Manufactured

No

250

Each

19.0000

1

1

D2741

Blade, 350, Skidtube

**

Location

Loc Qty

Loc Code

ST466

19

70667

19

D3532-1

Manufactured

No

250

Each

24.0000

2

2

D3532-1

Spacer

**

Location

Loc Qty

Loc Code

ST065

3

69895

3

ST068

21

73342

21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4988 M.C. J
11/10/14

RELEASED
6-29-12

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	REH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

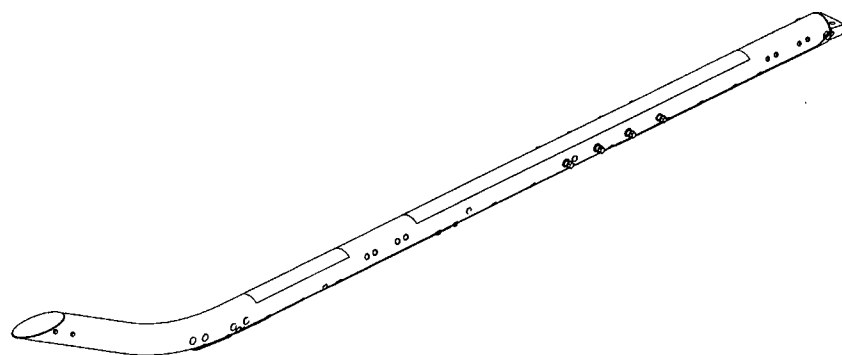
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

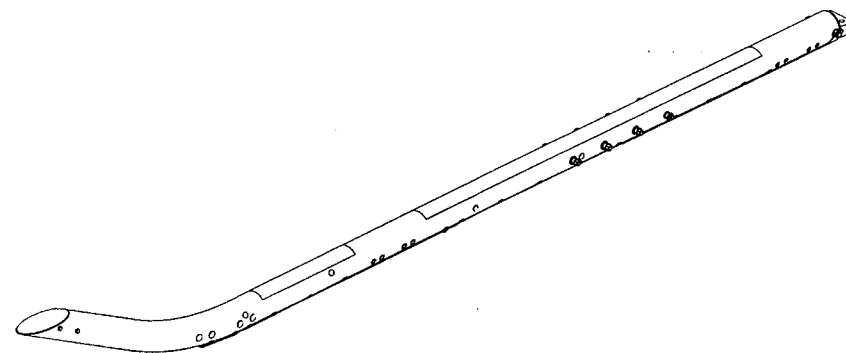
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
18 JUL 1998

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

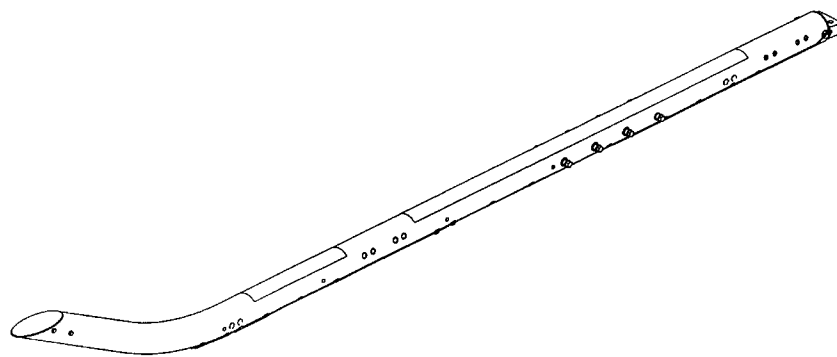
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

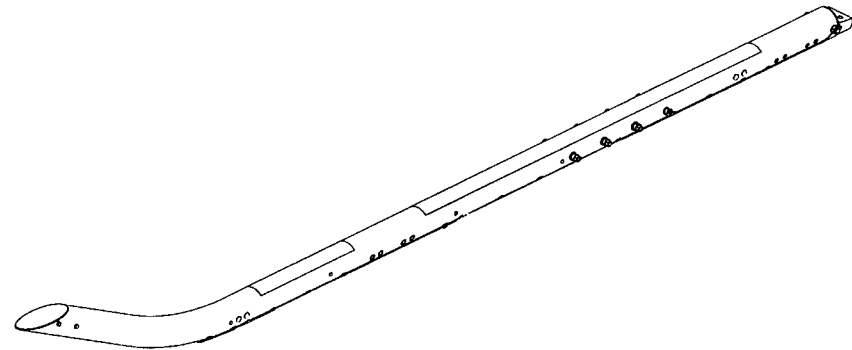
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
68-9-22/111

DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	MA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 3 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

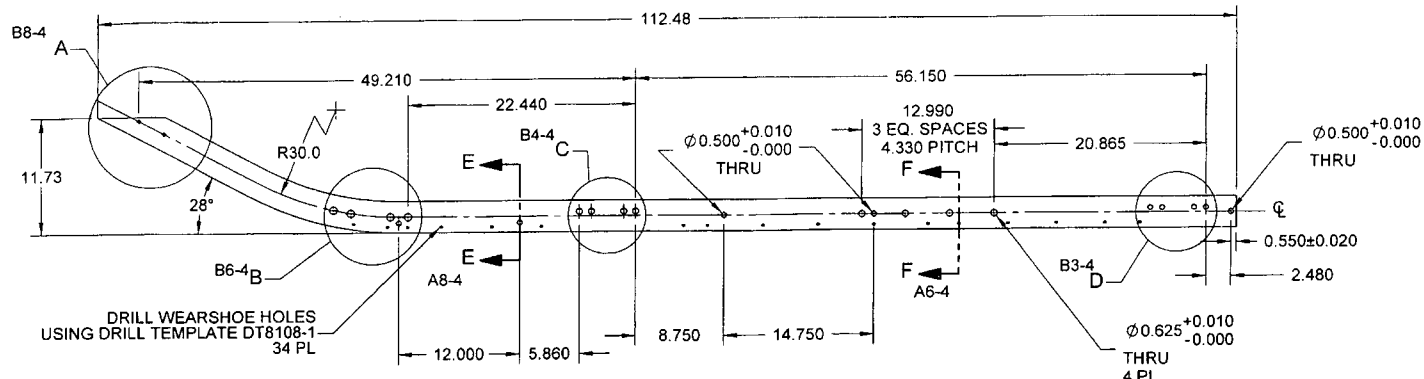
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

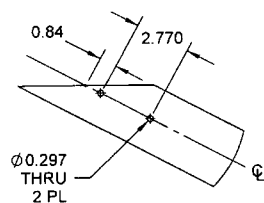
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

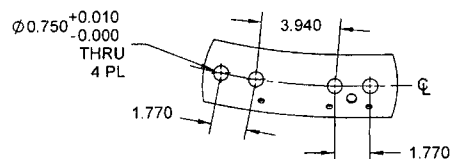
74988



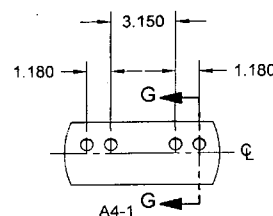
D2750-1 LH SKIDTUBE



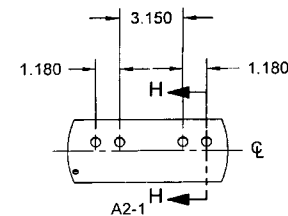
DETAIL A
SCALE 2X



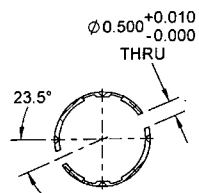
DETAIL B
SCALE 2X



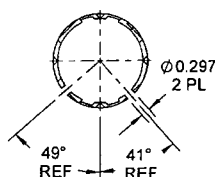
DETAIL C
SCALE 2X



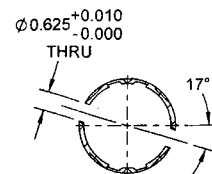
DETAIL D
SCALE 2X



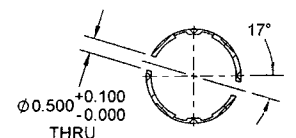
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

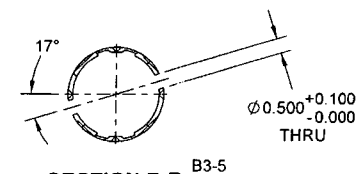
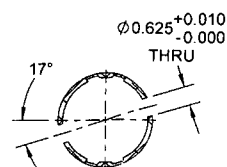
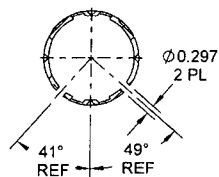
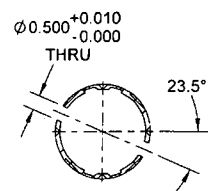
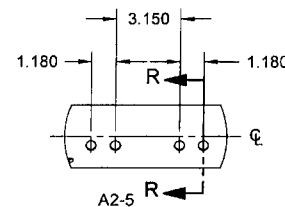
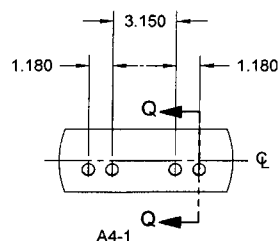
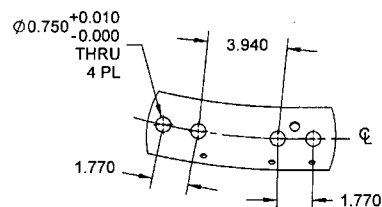
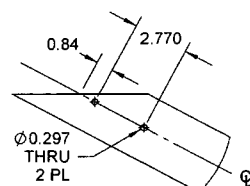
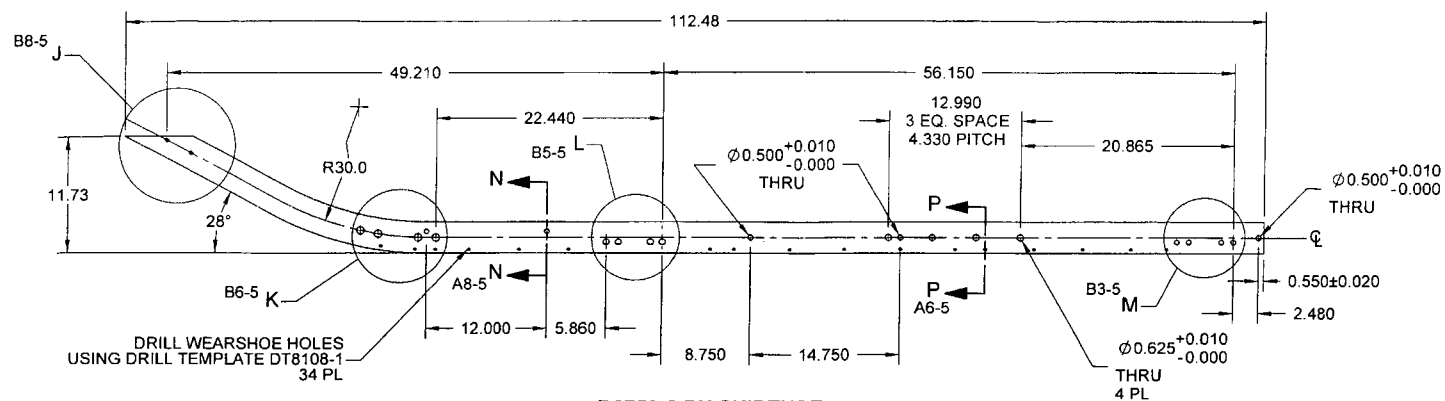
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



RELEASED

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

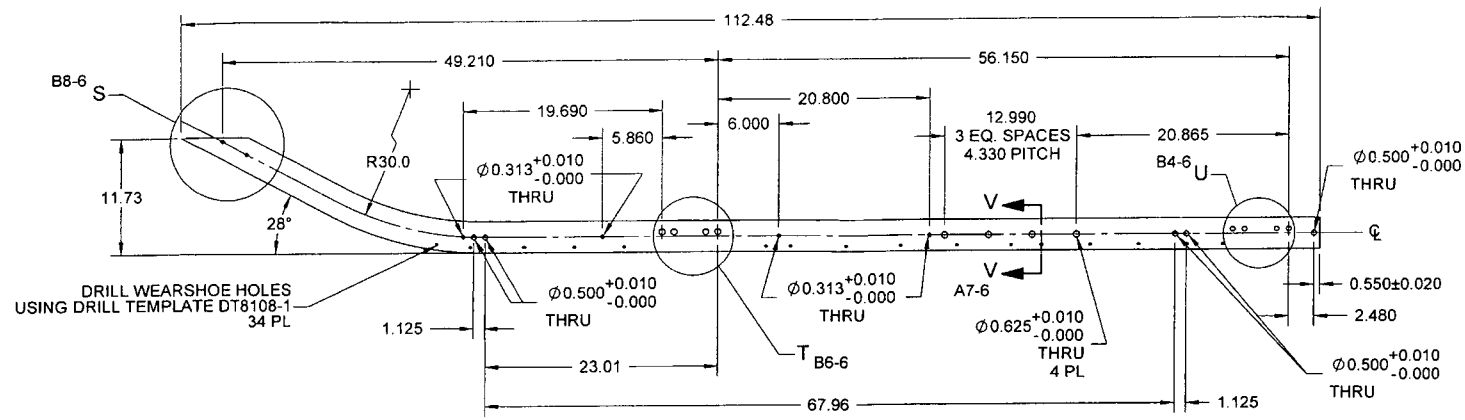
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

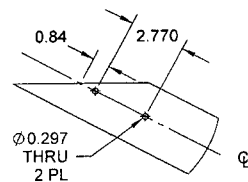
NOTE: Date & initial all entries

74988

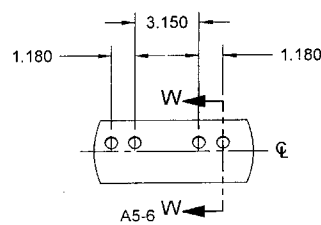
8 7 6 5 4 3 2 1



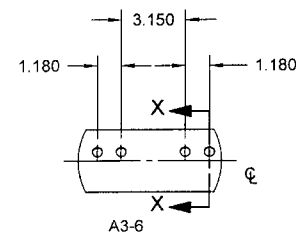
D2750-3 LH SKIDTUBE



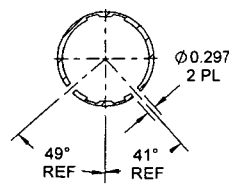
DETAIL S
SCALE 2X



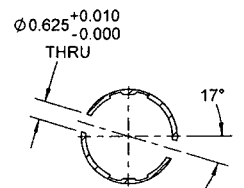
DETAIL T
SCALE 2X



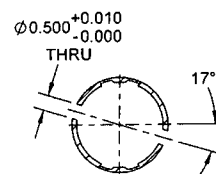
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

RELEASED

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

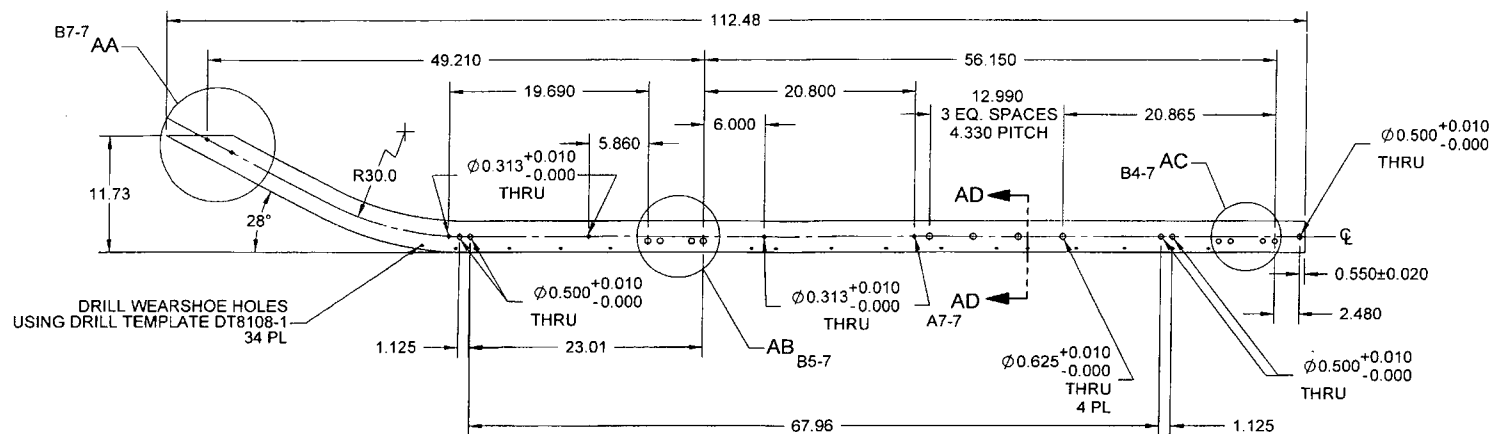
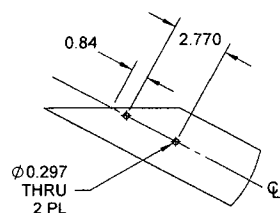
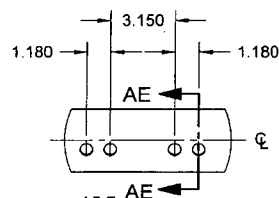
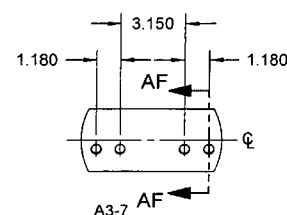
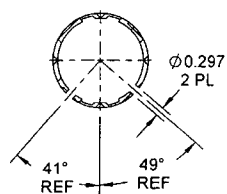
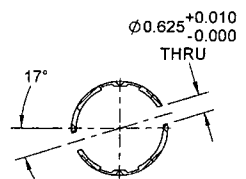
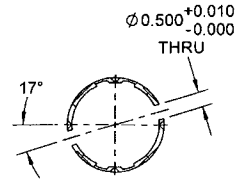
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____







Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988

**D2750-4 RH SKIDTUBE****DETAIL AA**
SCALE 2X**DETAIL AB**
SCALE 2X**DETAIL AC**
SCALE 2X**SECTION AD-AD**
SCALE 3X, 17 PL**SECTION AE-AE**
SCALE 3X, 4 PL**SECTION AF-AF**
SCALE 3X, 4 PL**RELEASED**

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

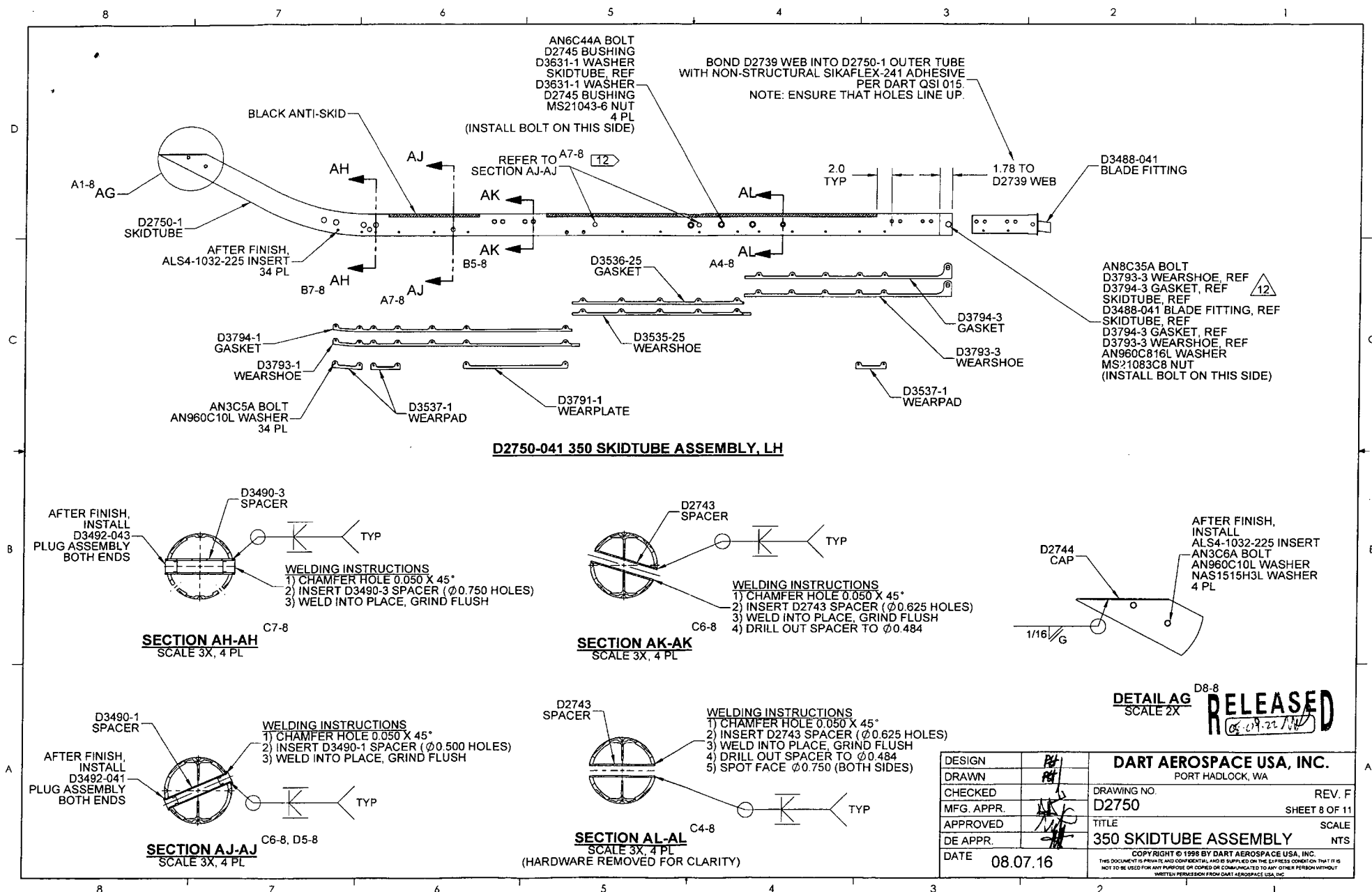
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

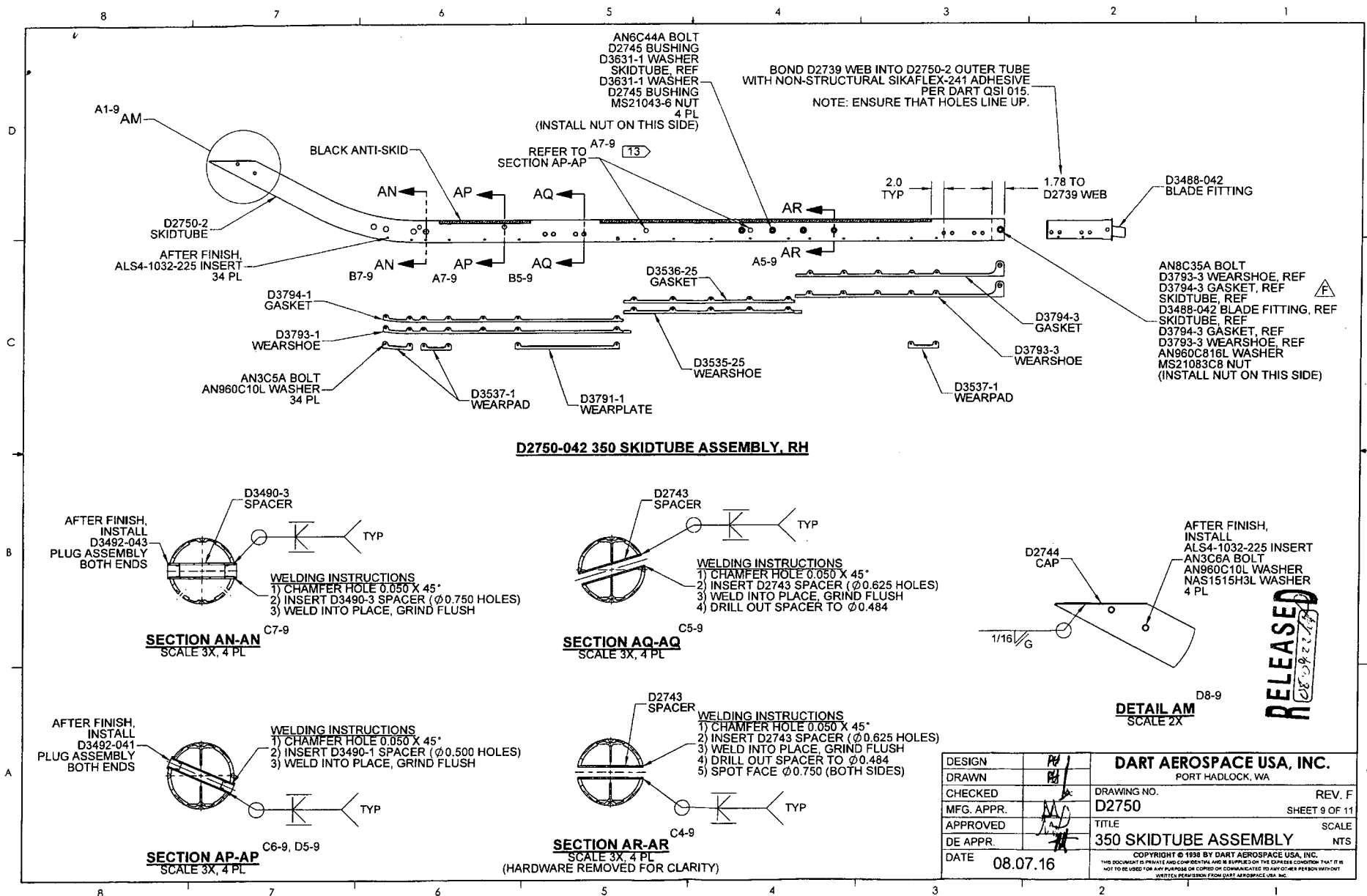
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

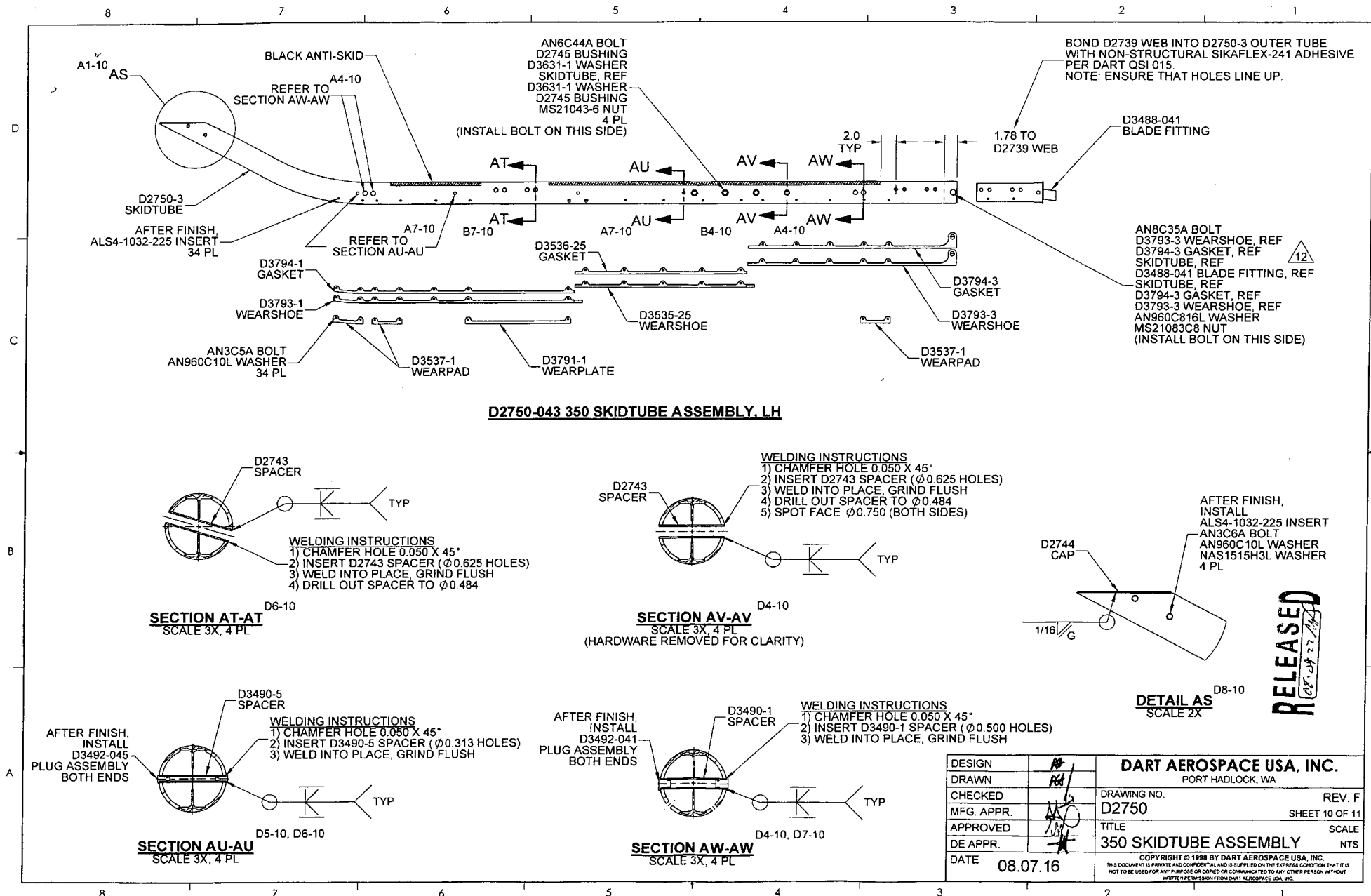
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

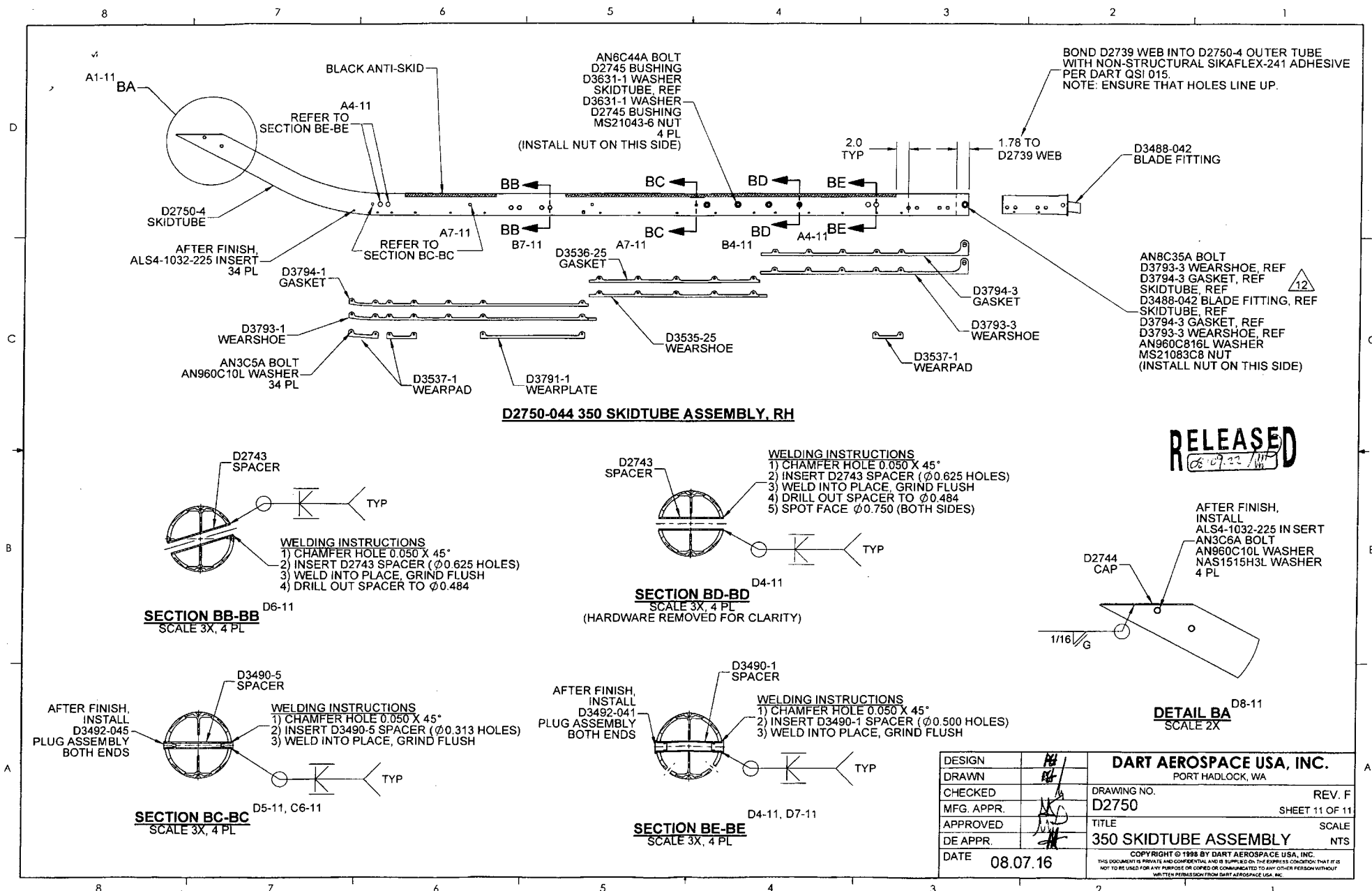
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74988



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries